

**Work Order ID 59324**

Tuesday, June 01, 2010 9:10:21 AM



Page 1

Item ID: D2989-043

Accept



Setup Start



Revision ID:

Item Name: Basket Lid Assembly

Stop



Start Date: 6/1/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/8/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-6-01

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2989

Rev D

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs in DT9446 jig, weld as per dwg D2989  
2- tack weld mesh on basket as per dwg D2989 using DT9446 jig  
3- to locate hinges and shims use D2989-041, weld as per dwg D2989  
A/R ER316 S.S. Rod Batch: 4113328

10-06-16

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							

Quality Control

130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
Powdercoat	Memo	0.00							

Powder Coating

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT  
 START TIME: 11:55  
 OVEN TEMPERATURE: 400°  
 FINISH TIME: 12:25  
 \*\*\*\*\* 2nd coat if necessary \*\*\*\*\*  
 2ND COAT:  
 START TIME: 1:05  
 OVEN TEMPERATURE: 400°  
 FINISH TIME: 1:35

①

BR 10-6-17.

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Cust Item ID:

Required Date: 6/8/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <i>G.A</i>	0.00							
Packaging	Memo <i>w/p 59321</i>	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

*EP 10/06/18* *EP 10/06/18* *10/06/18*   
*MF*  
*10-6-18*

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# Picklist Print

Tuesday, June 01, 2010 9:10:25 AM

Page 1

Work Order ID: 59324

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM  
IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC  
IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC  
IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Date: 6/1/2010

Required Date: 6/8/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D2221-1

Manufactured No

100

Each

16.0000

1

1



Rib



10/06/14

Location

Loc Qty

Loc Code

WA

16

57182

1

57499

3

58122

12

①

✓ D2989-3

Manufactured No

100

Each

7.0000

1

1



Rib



10/06/14

Location

Loc Qty

Loc Code

WA

7

57995

2

59006

2

59034

3

①

D2989-4

Manufactured No

100

Each

5.0000

1

1



Rib



10/06/14

Location

Loc Qty

Loc Code

WA

5

57996

2

58997

1

59036

2

①

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IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC  
IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Date: 6/1/2010

Required Date: 6/8/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D2989-5 Manufactured No 100 Each 8.0000 2 2  
Rib

Location	Loc Qty	Loc Code
WA	8	
57596	2	
58061	2	
59179	4	

✓ D3182-1 Manufactured No 100 Each 10.0000 2 2  
Hinge

Location	Loc Qty	Loc Code
WA	10	
57602	6	
59185	4	

✓ D3442-3 Manufactured No 100 Each 10.0000 2 2  
Shim

Location	Loc Qty	Loc Code
WA	10	
53137	4	
56204	6	

✓ D3827-041 Manufactured No 100 Each 7.0000 1 1  
Rib Assembly (Inboard)

Location	Loc Qty	Loc Code
WA	7	
57219	1	
57802	6	

Tuesday, June 01, 2010 9:10:25 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC  
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Date: 6/1/2010



Required Date: 6/8/2010

Start Qty: 1.00



Required Qty: 1.00

✓ D3832-5 Manufactured No 100 Each 4.0000 1 1  
  
 Mesh (Lid)  *PL 10.06.16*



Location	Loc Qty	Loc Code
WA	4	
57603	1	
57941	3	

✓ D3833-5 Manufactured No 100 Each 13.0000 2 2  
  
 Mesh (Lid End)  *PL 10.06.16*

Location	Loc Qty	Loc Code
WA	13	
53722	9	
57627	4	

✓ D3838-041 Manufactured No 100 Each 3.0000 1 1  
  
 Rib Assembly (Basket Lid, LH)  *B59187 ① 10/06/14*

Location	Loc Qty	Loc Code
WA	3	
57831	2	
58059	1	

✓ D3838-042 Manufactured No 100 Each 3.0000 1 1  
  
 Rib Assembly (Basket Lid, RH)  *B59188 ② 10/06/14*

Location	Loc Qty	Loc Code
WA	3	
57832	2	
58060	1	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**D2989-043 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

**D2989-041 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:**  
1) MATERIAL: N/A  
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs  
8) WELD PER DART QSI 004

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 59324  
PJ10-6-01

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

**RELEASED**  
08/11/18

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG) REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED		D2989	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET LID ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.09.24		

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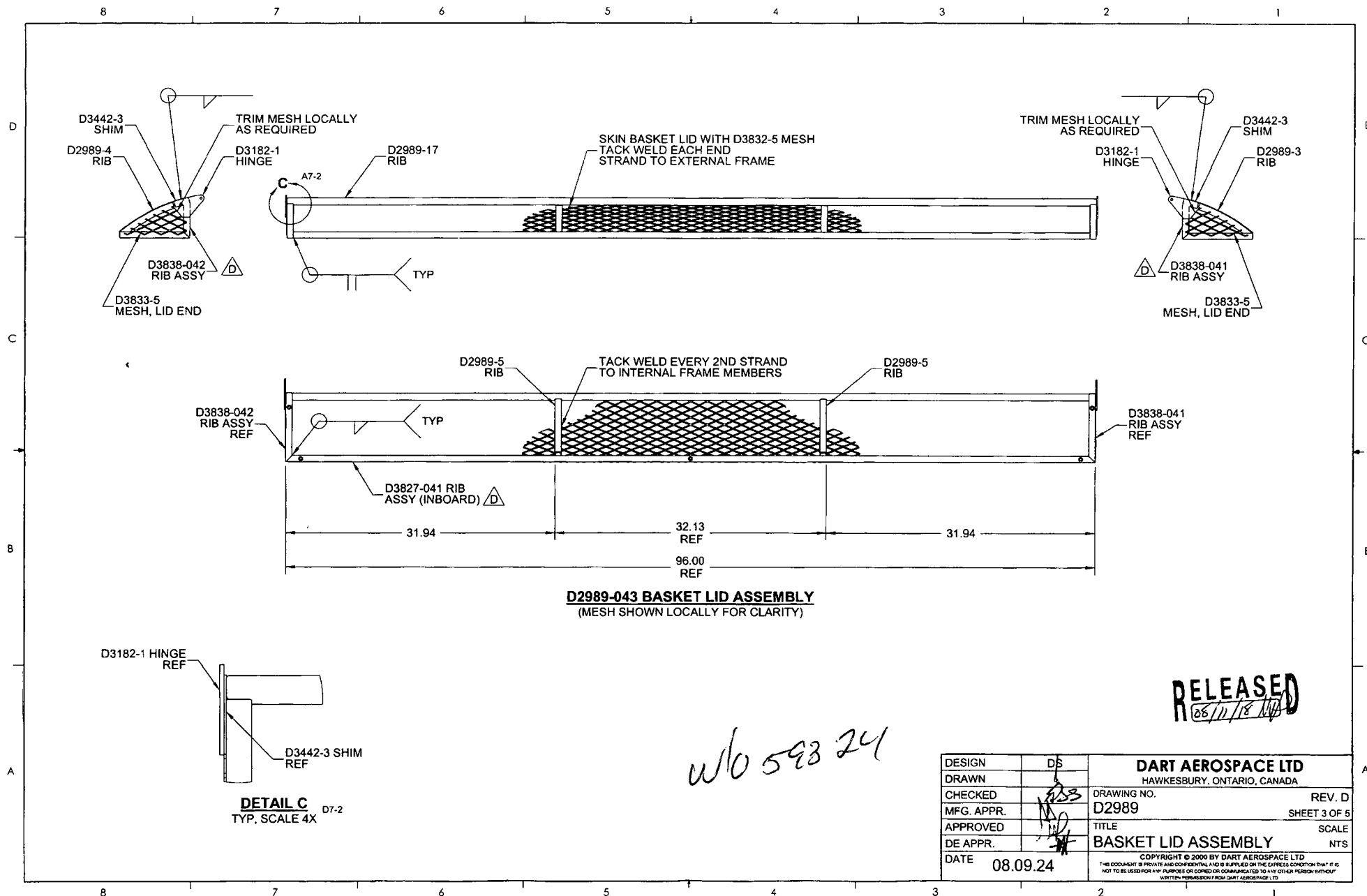
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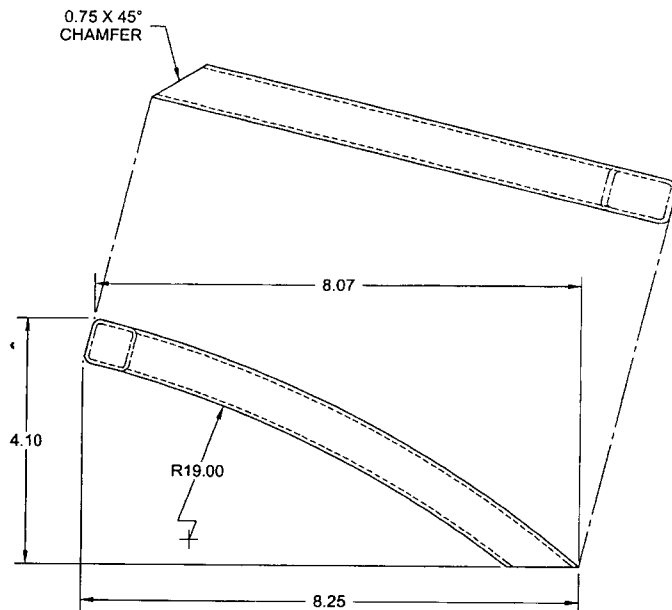
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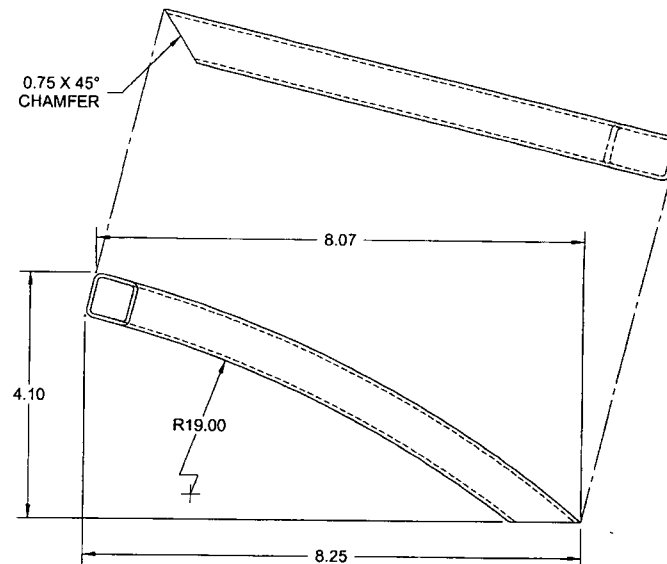
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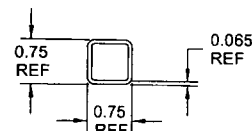
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**D2989-3 RIB**



**D2989-4 RIB**



**TYPICAL SECTION VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

*w/o 59324*

**RELEASED**  
08/11/18 NW

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

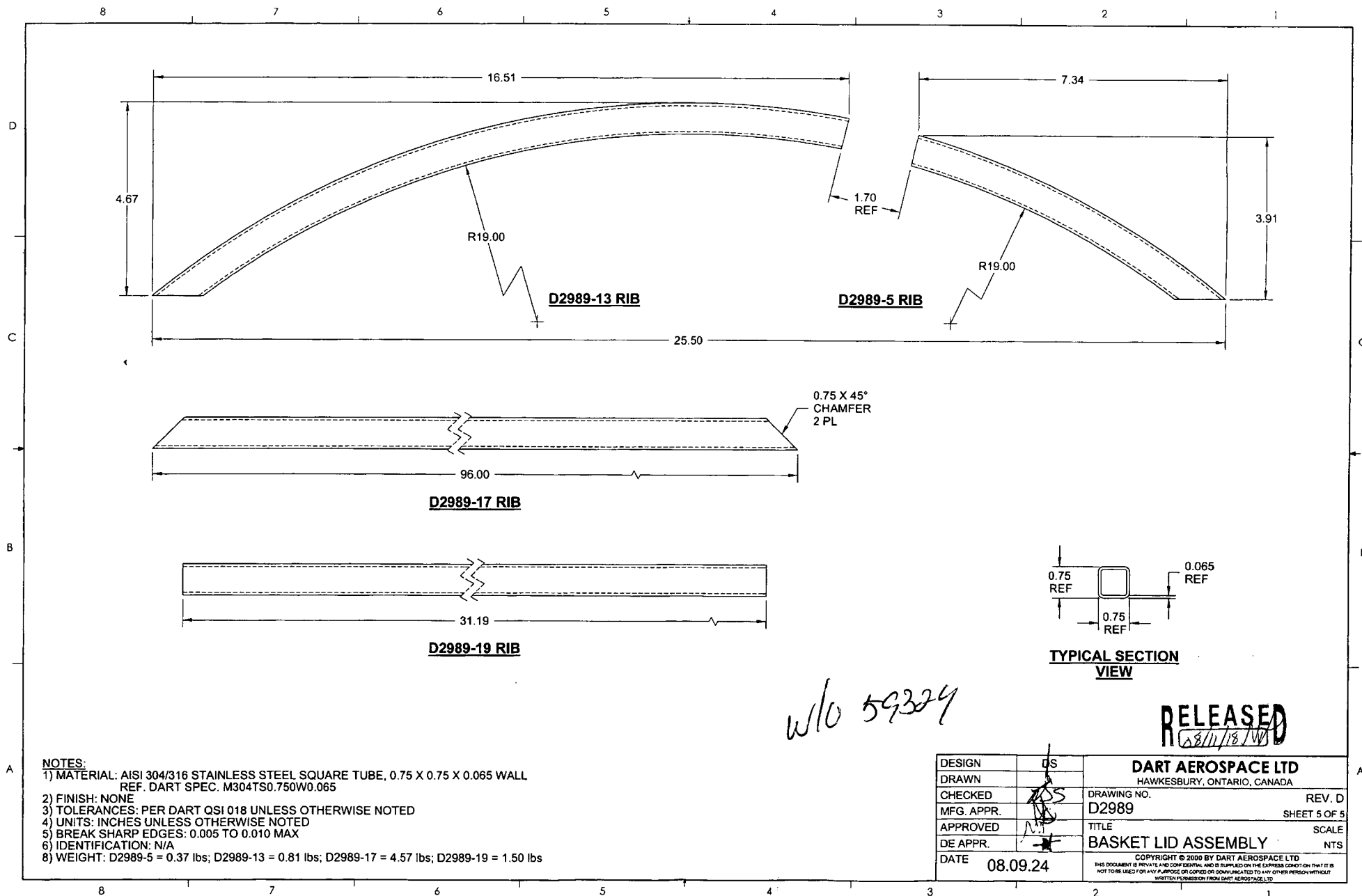
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